

Work Order ID 80356

February-17-12 12:09:37 PM

ASAP / Rush
80356

Page 1

Item ID: D3283-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 2/17/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/21/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3283

Rev E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3283

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

B 12-2-18

24

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-2-18

Work Order ID 80356

80356

Page 2

February-17-12 12:09:37 PM

Item ID: D3283-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler

Start Date: 2/17/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/21/12 Req'd Qty: 16.00

16

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 02 21 (25)

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Hand Finishing

Memo

W/A Need to be transferred
12.02.21

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

Work Order ID 80356

80356

Page 3

February-17-12 12:09:37 PM

Item ID: D3283-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 2/17/12 Start Qty: 16.00 *16*

Cust Item ID:

Required Date: 2/21/12 Req'd Qty: 16.00 *16*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

170

Identify as per dwg & Stock Location: LC

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

(24) BB 12/02/21

12/2/21

12-02-21 (24)

Picklist Print

February-17-12 12:09:37 PM

Page 1

Work Order ID: 80356

Parent Item: D3283-3

Parent Item Name: Doubler

Start Date: 2/17/12

Required Date: 2/21/12

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A04.09.28New issueKJ/JLM
IPP Rev:B As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No				sf	348.4000		5.5578947		8-12-2-18	

Location

Loc Qty

Loc Code

MAT021

348.4

117285

6.3

119766

164.5

120349

177.6

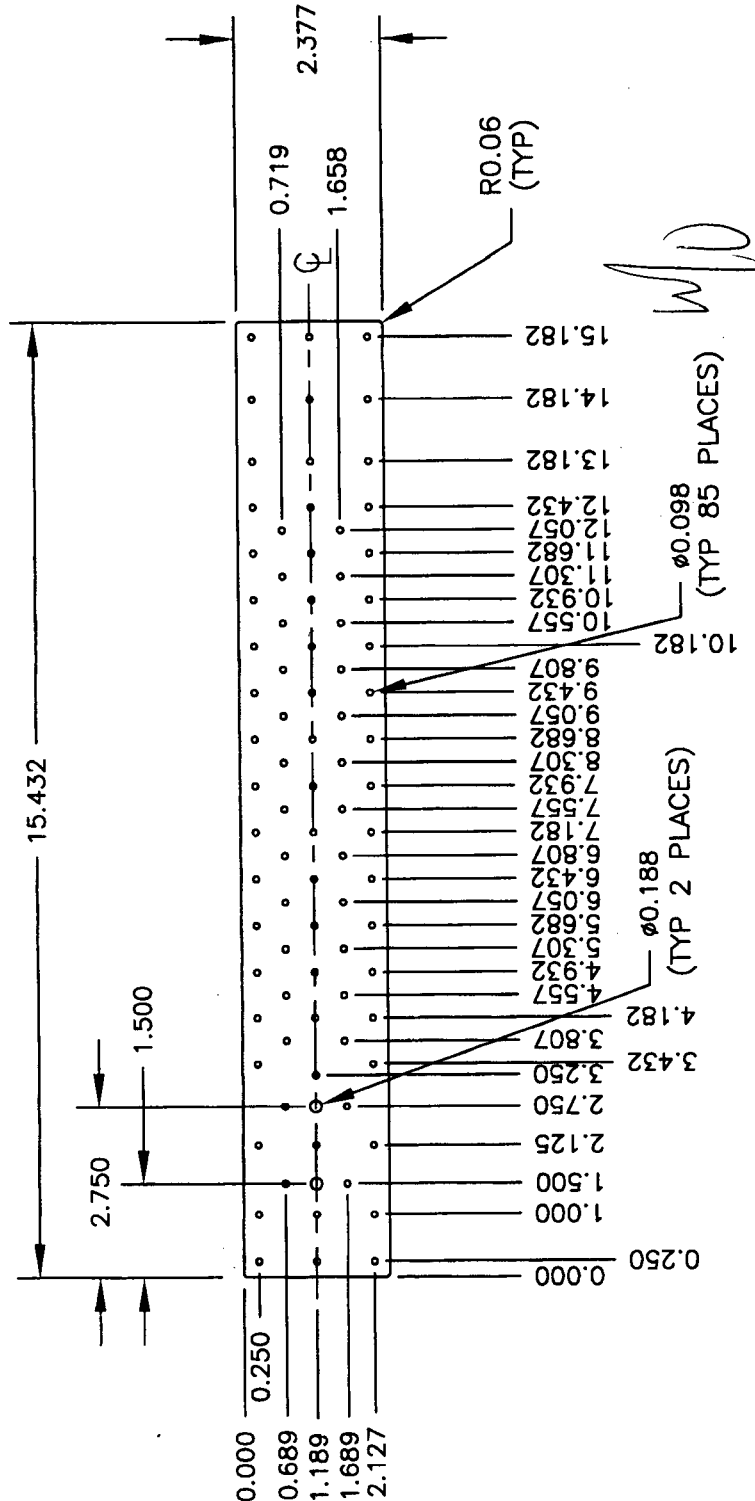
120349

241

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. E SHEET 2 OF 2
DATE 07.06.01		TITLE DOUBLER SCALE 1:3	

RELEASED
07-08-2004
PER ECN 959



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

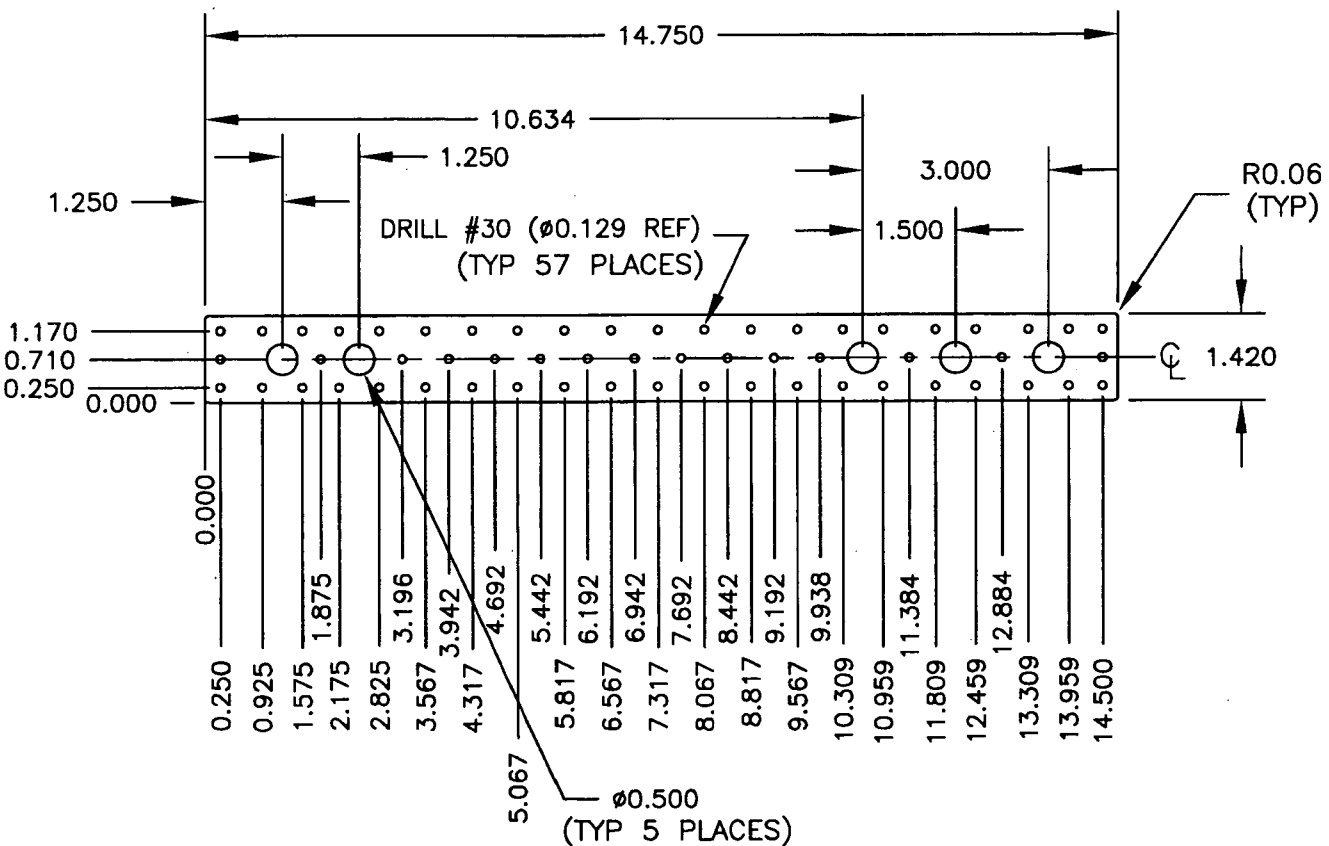
Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART

RELEASED
OCT 08 1964
PER ECN 959

DESIGN	99	DRAWN BY	DE	DART AEROSPACE USA, INC.	
CHECKED	JB	APPROVED	HH	PORT HADLOCK, WA	
DATE	07.06.01		TITLE	D3283	REV. E
A	04.05.06	NEW ISSUE	DOUBLER	SHEET 1 OF 2	
B	04.08.09	10.882 WAS 11.502		SCALE	
C	05.03.16	CHANGE HOLE PATTERN FOR -1		1:3	
D	05.08.09	REDESIGN			
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)			



D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE USA, INC.

Copyright © 2004 by DART AEROSPACE USA, INC.

DART AEROSPACE LTD	Work Order: 86356
Description: Doubler	Part Number: D3283-3
Inspection Dwg: D3283-3, Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.102	2		V	18-2
Ø .188	+ .005 - .001	.190	2		V	
.250	± .010	.248	2		V	
.689	± .010	.690	2		V	
1.189	± .010	1.190	2		V	
1.689	± .010	1.689	2		V	
2.127	± .010	2.129	2		V	
.719	± .010	.721	2		V	
1.658	± .010	1.656	2		V	
2.377	± .010	2.375	2		V	
2.750	± .010	2.747	2		V	
1.500	± .010	1.497	2		V	
15.432	± .010	15.432	2		T	18-1
1.000	± .010	1.000	2		V	
2.125	± .010	2.121	2		V	
2.750	± .010	2.747	2		V	
13.182	± .010	13.182	2		T	
14.182	± .010	14.182	2		T	
15.182	± .010	15.182	2		T	
.080	± .010	.078	2		V	

Measured by: B
Date: 12-2-18

Audited by: <i>[Signature]</i>
Date: 12.02.21

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	